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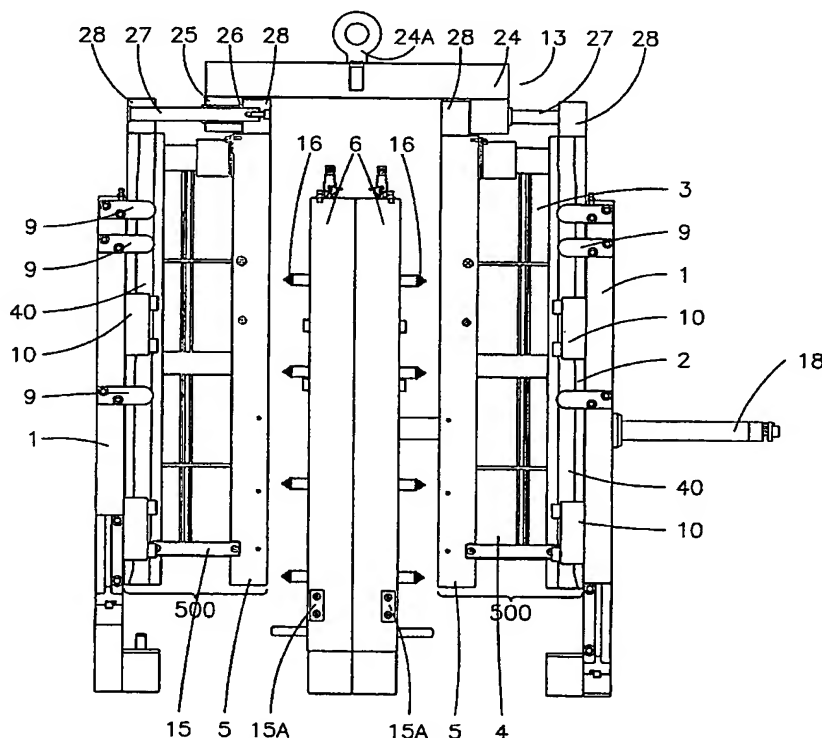
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(54) Title: **MODULAR MOLD CHANGE SYSTEM**



(57) Abstract: A method of removing components of an injection mold machine, comprising a core assembly including a master core plate (1), a core plate (2) releasably secured to said master core plate, said master core plate including guide means (9) for guiding said core plate (2) relative to said master core plate (1); a core insert (3) secured to said core plate (2); a cavity assembly comprising a manifold plate (6), a first cavity plate (5) releasably secured to the manifold plate (6), a cavity insert (4) attached to the cavity plate (5), said cavity assembly moveable relative to the core assembly such that the cavity insert (4) and core insert (3) may be selectively mated together to define a cavity therebetween, said method comprising the steps of: (a) moving the core assembly and cavity assembly into a closed position whereat the cavity insert and core insert are mated together; (b) securing said core plate to said cavity plate, thereby forming a mold module; (c) releasing the securing means which secures the cavity plate to the manifold plate; (d) opening the mold from the

closed position, until the first cavity plate disengages the manifold plate and all connections thereto, (e) releasing the securing means which secures the core plate to the master core plate; (f) lifting said mold module in a direction perpendicular to the direction of motion between said open and closed position, said module being guided in said perpendicular direction by said guide means.

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